



WI
HOU. NO.
WORK ORDER
NO. 41381

SHOP COPY
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ENGINEERING
JNC CONTROLLED COPY
SUBJECT TO AMENDMENT

PREMIER AVIATION, INC.			
2001 Aviation Parkway, Grand Prairie, Texas 75042			
SCALE:	CODE IDENT NO.	DOM NO.	REV.
D	DSUV8	B67-4300	B
SCALE:	WT.	SEAT	13 or 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:46:15 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 41381

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST513

AS 08/10/06 (xs)

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 (J)

Job Completion



U 08/10/06

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Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 41381

Part Number: PB674300151

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-30 (5)

7.0 PB674300189

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clevis

batch: 40093

SL 08-10-01

5

8.0 240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850

SL 08-10-01

5

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg

2- install spring pin

SL 08-10-01

5

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP

08-10-01 (5)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

4:00

OVEN TEMPERATURE:

320° F

FINISH TIME:

4:30

M/L 08/10/03

(5)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/03

(5)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LONG T-HANDLE ASSEMBLY	
Job Number	: 41381		Part Number	: PB674300151	
Estimate Number	: 13522		Drawing Number	: B6743001 P.13	
P.O. Number	:		Project Number	: N/A	
This Issue	: 18/08/2008 S.O. No. :		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 18/09/2008 Qty: 5	
Previous Run	: 40770			Um: Each	
Written By	:				
Checked & Approved By	: <u>JLD 08.8.18</u>				
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB674300187	Tube Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tube Arm batch: <u>341215</u> ✓ * W/O attached <u>Pl08.09.30</u>	
2.0	PB674300191	Tube Handle	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tube Handle batch: <u>341216</u> ✓ * W/O attached <u>Pl08.09.30</u>	
3.0	PB674300193	Tube End Cap	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Tube End Cap batch: <u>340074</u> ✓ * ST = deburr Sylvio <u>Pl08.09.30</u>	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1- drill #40 hole in center of -91 before welding -93 caps, to let air out 2- weld -93 to -91 as per dwg 3- grind weld flush 4- assemble -87 under the pilot hole in -91 and weld as per dwg <u>Pl08-09-30</u> X5	
5.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP <u>8/08/30/08</u>	